

# Work Order ID 55737

January 29, 2010 8:27:04 AM



Page 1

Item ID: D2364

Accept



Setup Start



Revision ID:

Stop



Item Name: Deck Plate, Fwd 350 Litt

Start Date: 1/28/10 Start Qty: 6.00



Cust Item ID:

Required Date: 2/08/10 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

*[Signature]*

Date: 10-1-29

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2364

Rev F

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2364 ☐ Dwg Rev: F ☐ Prog Rev: F ☐ 2-  
Deburr if necessary

IB 10-2-3

2024 .063

⑦

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

IB 10-2-3

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

S 10/02/06

④6

PN →

W/O: 55737		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10/02/08	120	Took qty x1 <sup>at</sup> For inspection template	S	10/02/08	+1		S 10/02/08

Part No: D2364 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130



Small Fab

Small Fab

Memo

0.00

0.00

1- counter sink holes as per dwg D236402- deburr if necessary

9/5/10/2/08 (6)

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

8/10/2/08

(XO)

150



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

Memo

0.00

0.00

8/10/2/09

X6

6

W/O:		WORK ORDER CHANGES					
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Page 3

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Start Date: 1/28/10 Start Qty: 6.00

Cust Item ID:

Required Date: 2/08/10 Req'd Qty: 6.00

Customer:

Reference:

Run Start

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME:

11:00AM

OVEN TEMPERATURE:

11:30AM FINISH TIME:

320°C

⇒ 10/02/09

10/02/09

XL6

φ

170

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

BK 10-02-9

6

φ

180

Identify as per dwg & Stock Location:

0.00



Packaging

Memo

0.00

Packaging

10/2/11 6

W/O:		WORK ORDER CHANGES					
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**Work Order ID 55737**

January 29, 2010 8:27:04 AM

Page 4

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Cust Item ID:

Required Date: 2/08/10 Req'd Qty: 6.00

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start

QC: Date: SPC (Y/N): Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/02/11 *[Signature]*  
mf  
10-2-11

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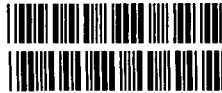
**NOTE:** Date & initial all entries



# Picklist Print

January 29, 2010 8:27:08 AM

Work Order ID: 55737



Parent Item: D2364

Parent Item Name: Deck Plate, Fwd 350 Litt

Start Date: 1/28/10

Required Date: 2/08/10

Comments: IPP REV. E 00.06.26 Removed P/O for powder coat EC  
IPP Rev:F Now On Waterjet 06-07-03 JLM

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M2024T3S.063		Purchased	No			100	sf	22.3696	4.0857	4.8		



2024-T3 .063 sheet



B 10-2-3

Warehouse                      Loc Qty                      Loc Code  
Location

Main Warehouse

MAT	22.36962419	
102942	1.5	
105916	1.09	
109463	0.00947368	
110980	5.4854	
111787	12.2847505	
19059	2	

113866

113866

7

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	<u>55737</u>
<b>Description:</b> Litter Deck Plate Kit (350)		<b>Part Number:</b>	D2364
<b>Inspection Dwg:</b> D2364	<b>Rev:</b> F	Page 1 of 1	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
6.624	+/-0.010	6.630	X			
Ø0.171	+0.005/-0.000	.175	X			
0.354	+/-0.010	.354	X			
11.242	+/-0.010	11.248	X			
3.031	+/-0.010	3.034	X			
1.903	+/-0.010	1.905	X			
1.128	+/-0.010	1.128	X			
0.354	+/-0.010	.354	X			
1.340	+/-0.005	1.340	X			
2.326	+/-0.010	2.325	X			
3.312	+/-0.010	3.310	X			
4.298	+/-0.010	4.295	X			
5.284	+/-0.010	5.283	X			
6.151	+/-0.010	6.154	X			
6.270	+/-0.010	6.270	X			
0.354	+/-0.010	.354	X			
3.031	+/-0.010	3.030	X			
Ø0.656	+0.005/-0.000	.656	X			
5.003	+/-0.010	5.003	X			
4.605	+/-0.010	4.601	X			
1.776	+/-0.010	1.775	X			
0.980	+/-0.010	.981	X			
4.487	+/-0.010	4.490	X			
7.192	+/-0.010	7.197	X			
7.567	+/-0.010	7.575	X			
7.942	+/-0.010	7.947	X			
Ø0.191	+0.005/-0.000	.192	X			
Ø0.197	+0.005/-0.000	.199	X			
11.145	+/-0.010	11.150	X			
12.181	+/-0.010	12.181	X			
11.378	+/-0.010	11.375	X			
11.776	+/-0.010	11.776	X			
12.173	+/-0.010	12.173	X			
4.690	+/-0.010	4.682	X			
0.250	+0.005/-0.000	.254	X			
3.141	+/-0.010	3.143	X			
Ø 0.171	+0.005/-0.000	.173	X			

<b>Measured by:</b>	<u>RB</u>	<b>Audited by:</b>	<u>S</u>	<b>Prototype Approval:</b>	N/A
<b>Date:</b>	<u>10-2-08</u>	<b>Date:</b>	<u>10/02/08</u>	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	04.06.25	New Issue P/O D350-616-015	KJ/JLM	
B	08.05.28	7.567 dimension revised	KJ/DD	

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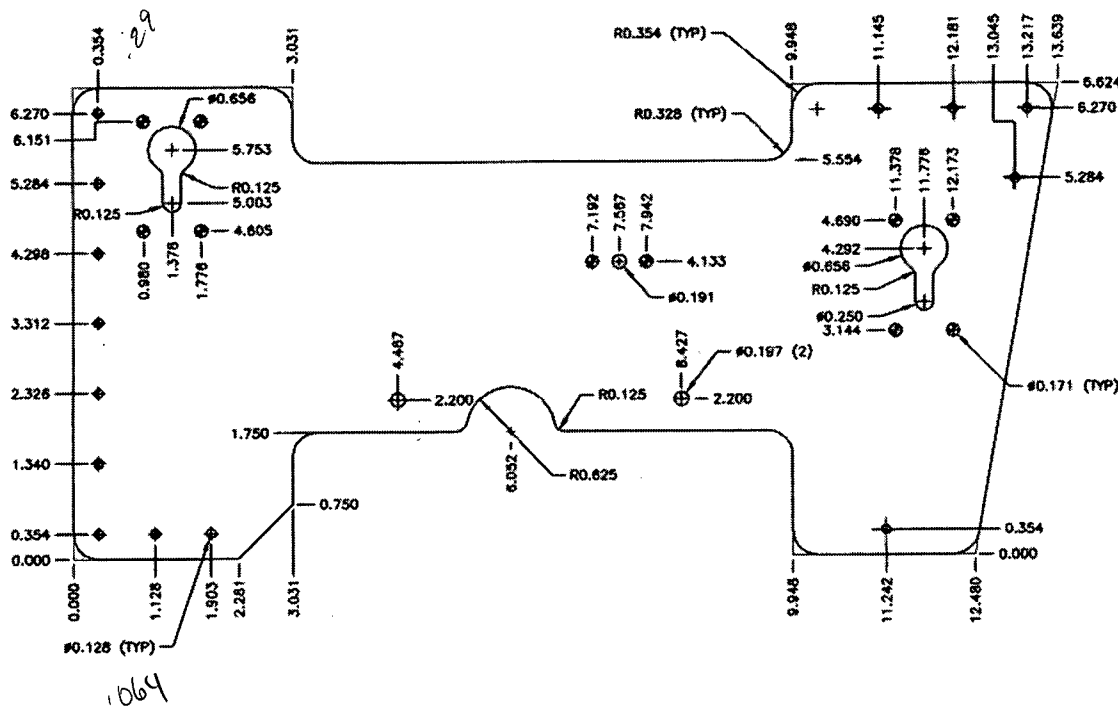
**DART**



**RELEASED**  
98/06/22 KE

DESIGN	DRAWN BY	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA
CHECKED <i>KE</i>	APPROVED <i>KE</i>	
DATE 98.06.19	DRAWING NO. D2364	REV. F
	TITLE LITTER DECK PLATE, 350	SHEET 1 OF 1
A	95.01.14	NEW ISSUE
B	95.02.09	MOVED KEYWAY
D	95.03.06	0.191 WAS 0.197
E	95.10.06	GEOMETRY CHANGES
F	98.06.19	0.063-0.071 THICK WAS 0.071 (TSR A371)

- COUNTER SINK HOLES:  
 ♦ C'SINK  $\varnothing 0.225 \times 100^\circ$  (UPDATED FROM 9 TO 14 HOLES BY DS 99.03.01 TO CORRECT CAD ERROR)  
 ● C'SINK  $\varnothing 0.308 \times 100^\circ$



MATERIAL: 2024-T3 (QQ-A-250/5) 0.063-0.071 THICK  
 FINISH: POWDER COAT BLACK CRINKLE (4.3.5.3) PER DART QSI 005 4.3  
 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP  
 RET.  
 ENG.  
 UNCON.  
 SUBJECT TO SATISFACTION  
 WITHOUT PRECEDENT

WORK ORDER NO. 35237

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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